

# Work Order ID 63504

Wednesday, November 03, 2010 11:12:13 A



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-11-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

801222

HJ for BG 10-12-1

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M108436  
M114877

3-Grind End Plate flush

10-11-22 10 P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				10	0	BE10/11/23	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				410 RTR	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				10	0		

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
180 Large Fab Large Fab	Large Fab  Memo	0.00 0.00							
	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <u>M108436</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				10	0	BE 10/11/30	
200  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
210  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	<i>M 115951.</i>					<i>10</i>		<i>BL 10-12-1</i>	
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>9:15</i>								
	OVEN TEMPERATURE: <i>300°</i>								
	FINISH TIME: <i>9:45</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch <i>M 115740</i>	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

*=> M 10/12/01*

*10RH 0*

*8 10/12/02*

*210  
RH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Stamp
250  Packaging Packaging	Pick Kit  Memo	0.00  0.00							<u>10/12/2 900</u>
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							<u>10/12/2</u>
270  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPPD350-591-312 Location: <u>411</u>	0.00  0.00							<u>10/12/2</u>

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Required Date: 12/10/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/03 [Signature]  
MF  
10-12-02

W/O:		WORK ORDER CHANGES					
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...the ...



**Required Date: 12/10/2010**

**Required Qty: 10.00**

**Comments:** IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D  
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1  End Plate		Manufactured	No			110	Each	136.0000	1	10		10.11.22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				136					
				60141				5					
				62664				131					
D3219-1  Plate		Manufactured	No			110	Each	61.0000	2	20		10.11.22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				61					
				61204				61					
D3272-1  Step		Manufactured	No			110	Each	0.0000	1	10		10.11.11	B63505
D3065-041  Step Leg Assembly Hi		Manufactured	No			180	Each	162.0000	1	10		10.11.29	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				134					
				63324				134					
				WA				28					
				61216				3					
				62224				25					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63504

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Parent Item Name: Heli-Access-Step, Long

Start Date: 11/3/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each

87.0000 2 20



Spacer

## Location

## Loc Qty

## Loc Code

WA

87

62662

87

D3067-1 Manufactured No

180 Each

136.0000 1 10



End Plate

## Location

## Loc Qty

## Loc Code

WA

136

60141

5

62664

131

MS20600-AD4W4 Purchased No

180 Each

1,875.000 16 160



Rivets

## Location

## Loc Qty

## Loc Code

ST321

1875

113368

38

114181

11

114718

2

115573

147

115640

677

116022

1000

AN3-35A Purchased No

250 Each

139.0000 2 20



Bolt

## Location

## Loc Qty

## Loc Code

ST353

139

115457

39

115936

100

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Shop Packet Print

Page 2

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Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/3/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

413.0000

8

80



Bolt

## Location

## Loc Qty

## Loc Code

ST357

300

115936

300

ST358

113

115159

113

AN5-36A

Purchased

No

250

Each

147.0000

2

20



Bolt

## Location

## Loc Qty

## Loc Code

ST340

100

115936

100

ST341

47

114292

5

114941

42

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

40



Washer

## Location

## Loc Qty

## Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

24.0000

16

160



Washer

## Location

## Loc Qty

## Loc Code

ST300

24

113288

24

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Shop Packet Print

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Start Date: 11/3/2010

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Start Qty: 10.00

Required Qty: 10.00

S  
710 AN960JD516 NAS1149D0563J Purchased No  
Washer

Location	Loc Qty	Loc Code
ST	34	
103694	18	
107534	12	
109287	4	

34.0000 4 40  
M114742 10/12/25  
M113524

S  
710 D2230-3 Manufactured No  
Lug

Location	Loc Qty	Loc Code
ST476	90	
55452	2	
62660	88	

90.0000 4 40  
B63544 10/12/25

S  
710 D2618 Manufactured No  
Bushing

Location	Loc Qty	Loc Code
ST019	151	
60772	51	
62213	100	
ST020	2	
56892	1	
57829	1	

153.0000 2 20  
10/12/35 10x

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Start Date: 11/3/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

175.2500 1.2



Abraison Strip



12/10/2010

## Location

## Loc Qty

## Loc Code

ST403

175.2500421

56626

0.00004211

59920

175.25

12

cut (2) D2856-400-720 as per dwg

D3235-1

Manufactured No

250 Each

57.0000 2



Mounting Lug



20 B62214 12/10/2010

## Location

## Loc Qty

## Loc Code

ST471

57

60851

20

61845

37

D3278-041

Manufactured No

250 Each

62.0000 1



Support Assembly



10 12/10/2010

## Location

## Loc Qty

## Loc Code

ST471

62

61212

32

62395

30

MS21042L3

Purchased No

250 Each

1,890.000 2



Nut



20 12/10/2010 (100)

## Location

## Loc Qty

## Loc Code

ST300

1890

114784

890

115835

1000

20

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Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

2,781.000

8

80



10/12/2 SP

Nut

Location

Loc Qty

Loc Code

ST300

2781

113422

25

114523

8

115589

1648

115621

1100

80

MS21042L5

Purchased

No

250

Each

747.0000

2

20



10/12/2 SP 100

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

721

115156

221

115594

500

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *H*

REFERENCE ONLY

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

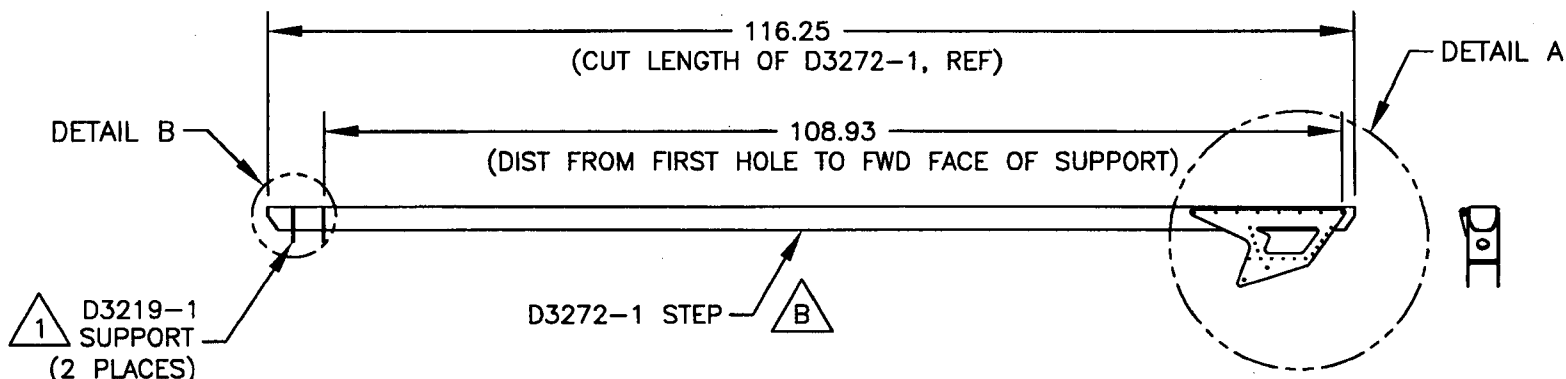
**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

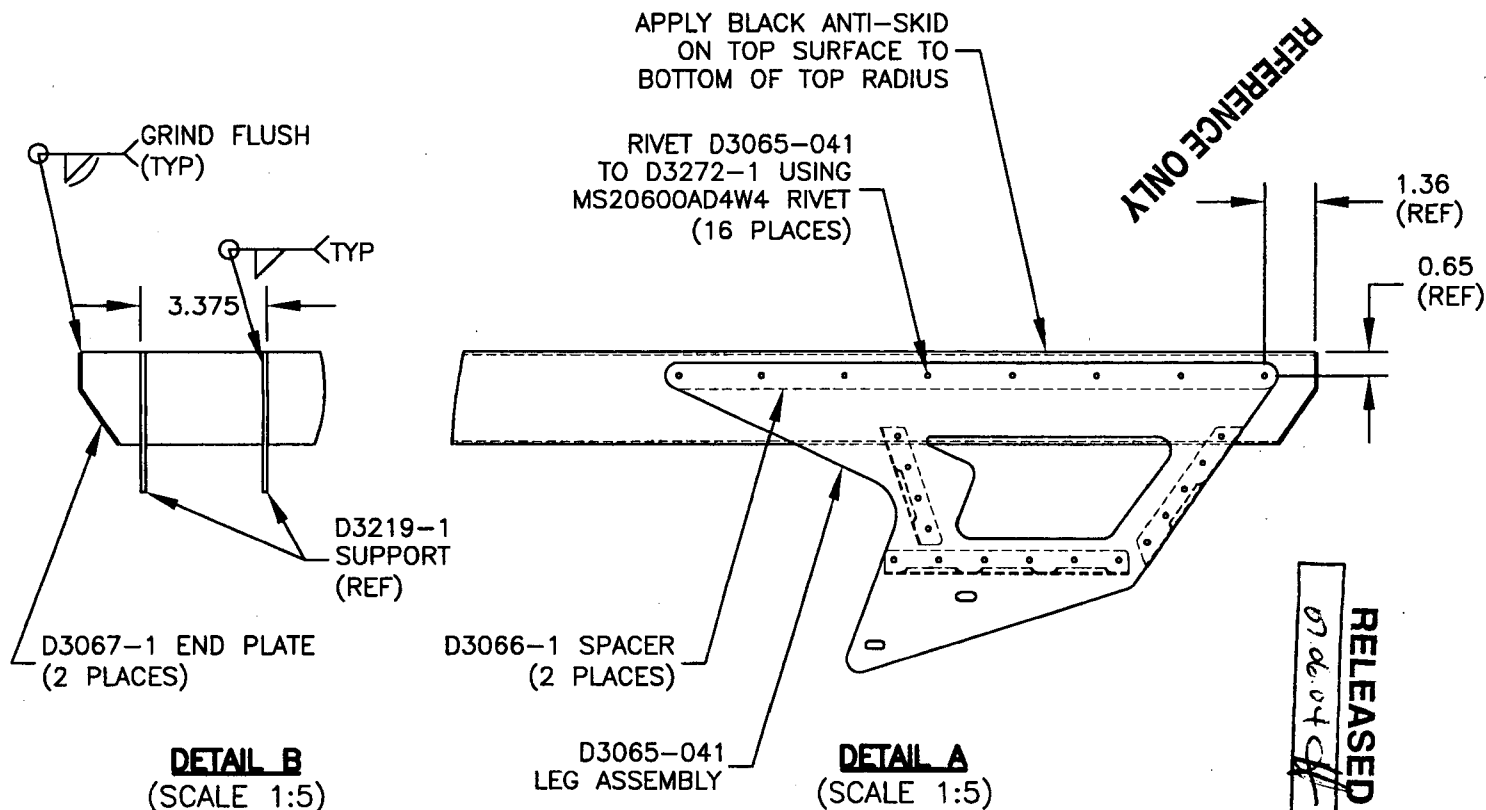
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**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**

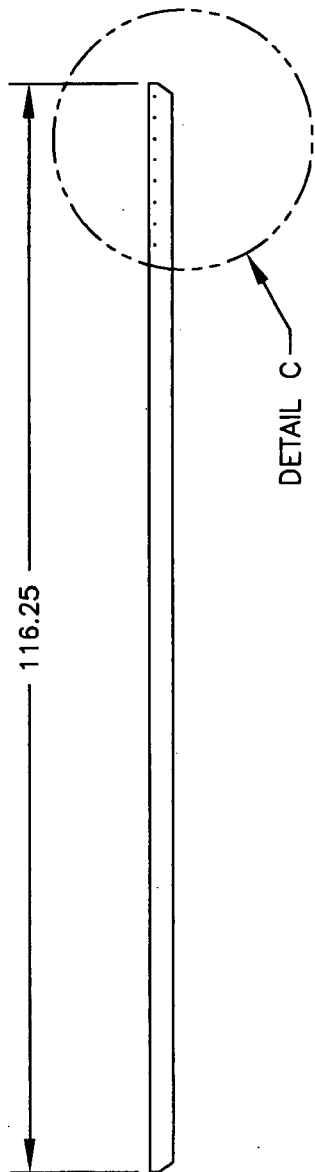


**RELEASED**  
 07.06.04

DESIGN	q	DRAWN BY	B	DART AEROSPACE LTD
CHECKED	Le	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

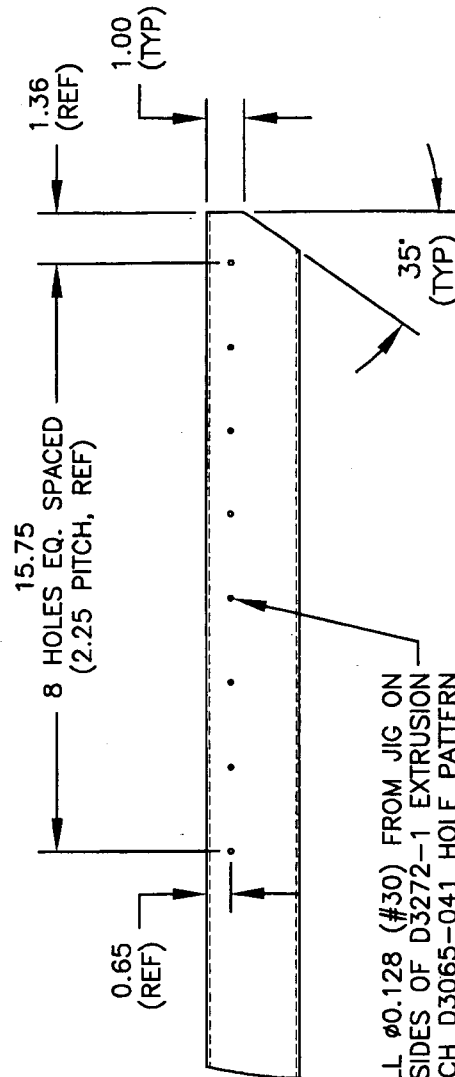


DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

REFERENCE ONLY



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.